

SRir

Work Order ID 69589-3

Thursday, May 12, 2011 2:38:30 PM



Item ID: D3372-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Collective Lock Assembly

Start Date: 5/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

MF

Date: 11-05-12 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372 Identify as D3372-3

EP 11/05/24

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

SB 11/05/24

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open Cam Lock package Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.  
2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

SB 11/05/30

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Work Order ID 69589

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Page 3

Item ID: D3372-041

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

11

# Work Order ID 69589

Thursday, May 12, 2011 2:38:30 PM



Page 2

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Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

1-Assemble D3372-053 as per Dwg D3372 Apply a drop of permanent locktite 262 to the threads

Qty Part Number Description Batch

A/R N/A Locktite 262 H13436

Identify as D3372-053

2-Assemble D3372-051 as per Dwg

140



Large Fab

Large Fab

0.00

Memo

0.00

Tack weld lock shaft as per Dwg D3372

A/R SS Rod Batch H15428

SS 1165/30

Q110530

W/O:		WORK ORDER CHANGES					
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Start Date: 5/13/2011 Start Qty: 1.00

Required Date: 5/20/2011 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

180



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11/06/02  
mf  
11-06-02

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Page 1

Work Order ID: 69589

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly



Start Date: 5/13/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM  
IPP Rev:B Added Key ID 06.03.21 EC  
added D3384-043 DD 10 05.13 verified :EC IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16WC  
  
SS Flat Washer 5/16 FW516S1

Purchased No

100 Each 3.387 000 2 2



SN 1165/30

Location	Loc Qty	Loc Code
st376	2000	
117332	2000	
ST377	1387	
115072	100	
115174	65	
116643	1222	

AN5-42A  
  
Bolt

Purchased No

100 Each 26.0000 1 1



SN 1105/30

Location	Loc Qty	Loc Code
ST341	26	
108442	26	

AN960-416  
  
Washer

NAS1149F0463P Purchased No

100 Each 0.0000 2 2



SN 1165/30

D2728-7

Manufactured No

100 Each 0.0000 0 0



SN 1165/30

Dart Logo label  
D3372-1

Manufactured No

100 Each 0.0000 1 1



SN 1165/30

Main Body

B 69 631

W/O:		WORK ORDER CHANGES					
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Thursday, May 12, 2011 2:38:28 PM

Page 2

Work Order ID: 69589

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 5/13/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3372-5 Manufactured No

100

Each

5.0000

1

1



Cam Lock Shaft

Location

Loc Qty

Loc Code

ST048

5

59557

5

100

Each

1.0000

1

1

D3372-7



Slider Body

Manufactured No

Location

Loc Qty

Loc Code

ST485

1

58439

1

100

Each

20.0000

1

1

D3373-1



Cam Lock

Manufactured No

Location

Loc Qty

Loc Code

ST049

20

58463

20

100

Each

0.0000

1

1

D3384-043



Cyclic Sock Assembly

Manufactured No

HX-81



1/4"-20 SHCS 3/8" long

Purchased No

Location

Loc Qty

Loc Code

ST390

33

114383

33

100

Each

33.0000

1

1

Thursday, May 12, 2011 2:38:28 PM

Shop Packet Print

Page 2

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

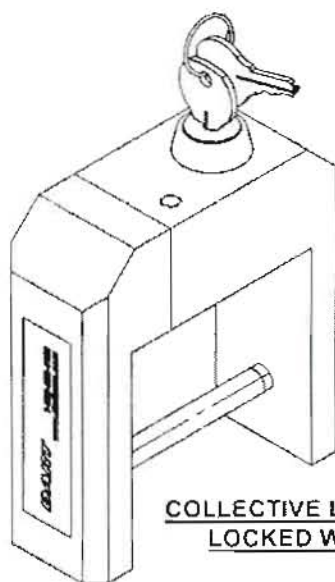
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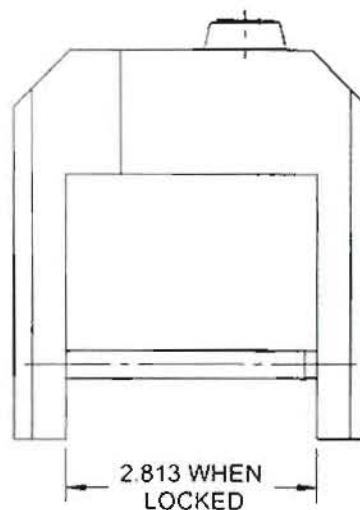
NOTE: Date & initial all entries

**DART**

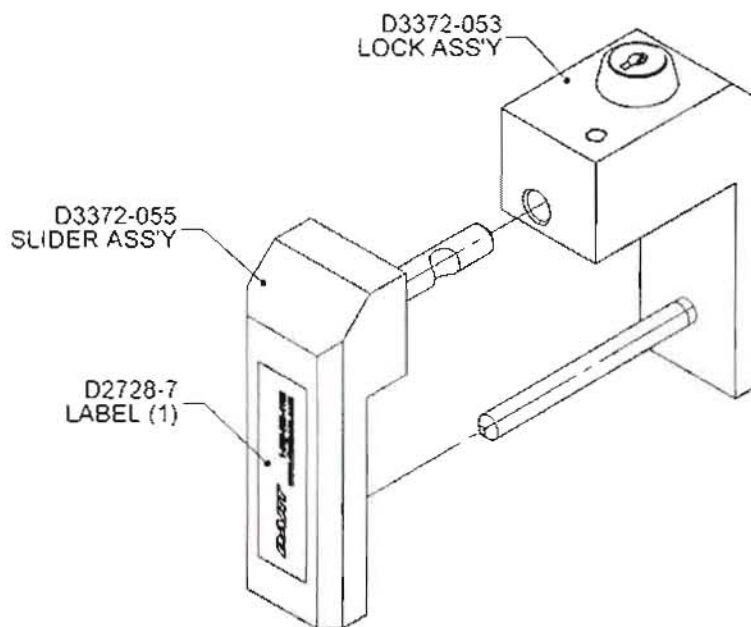
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS



2.813 WHEN  
LOCKED



RELEASED  
*[Signature]*  
05/04/28

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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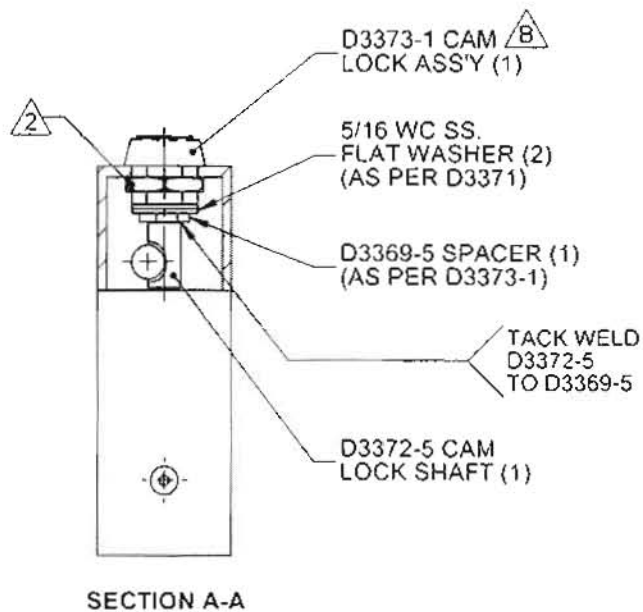
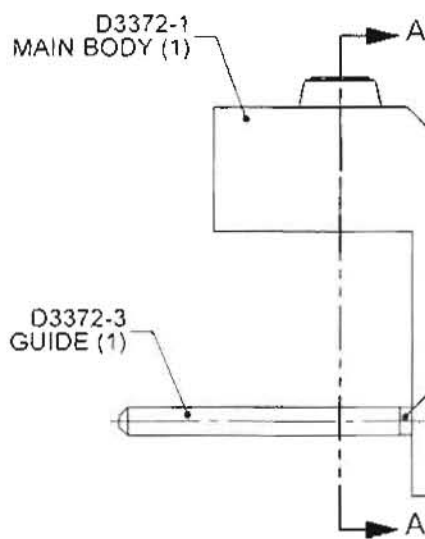
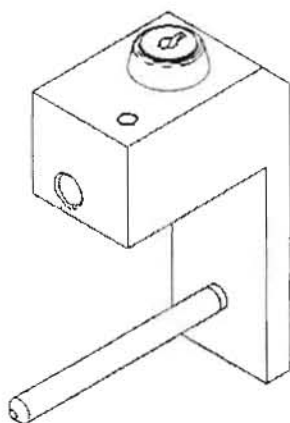
NOTE: Date & initial all entries



**DART**

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3372	REV. B SHEET 2 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

RELEASED  
[Signature]  
25/04/23



### D3372-053 LOCK ASS'Y

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

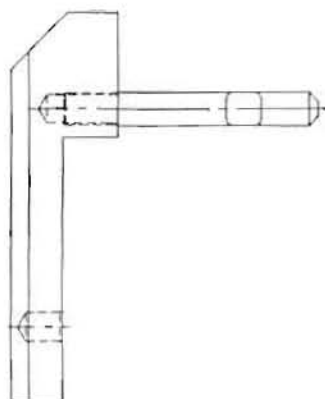
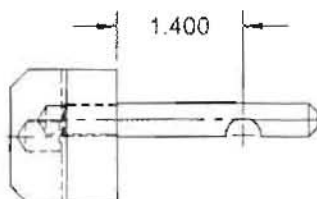
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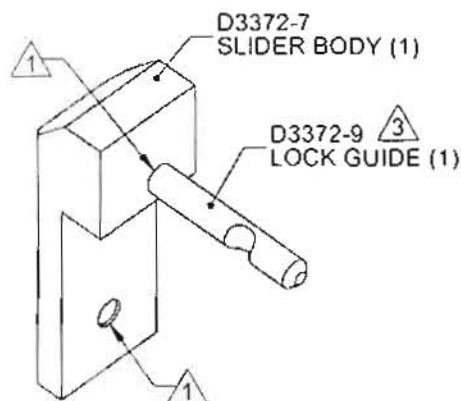
NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 3 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2

**RELEASED**

05/04/23

**D3372-055 SLIDER ASS'Y****NOTES:**

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

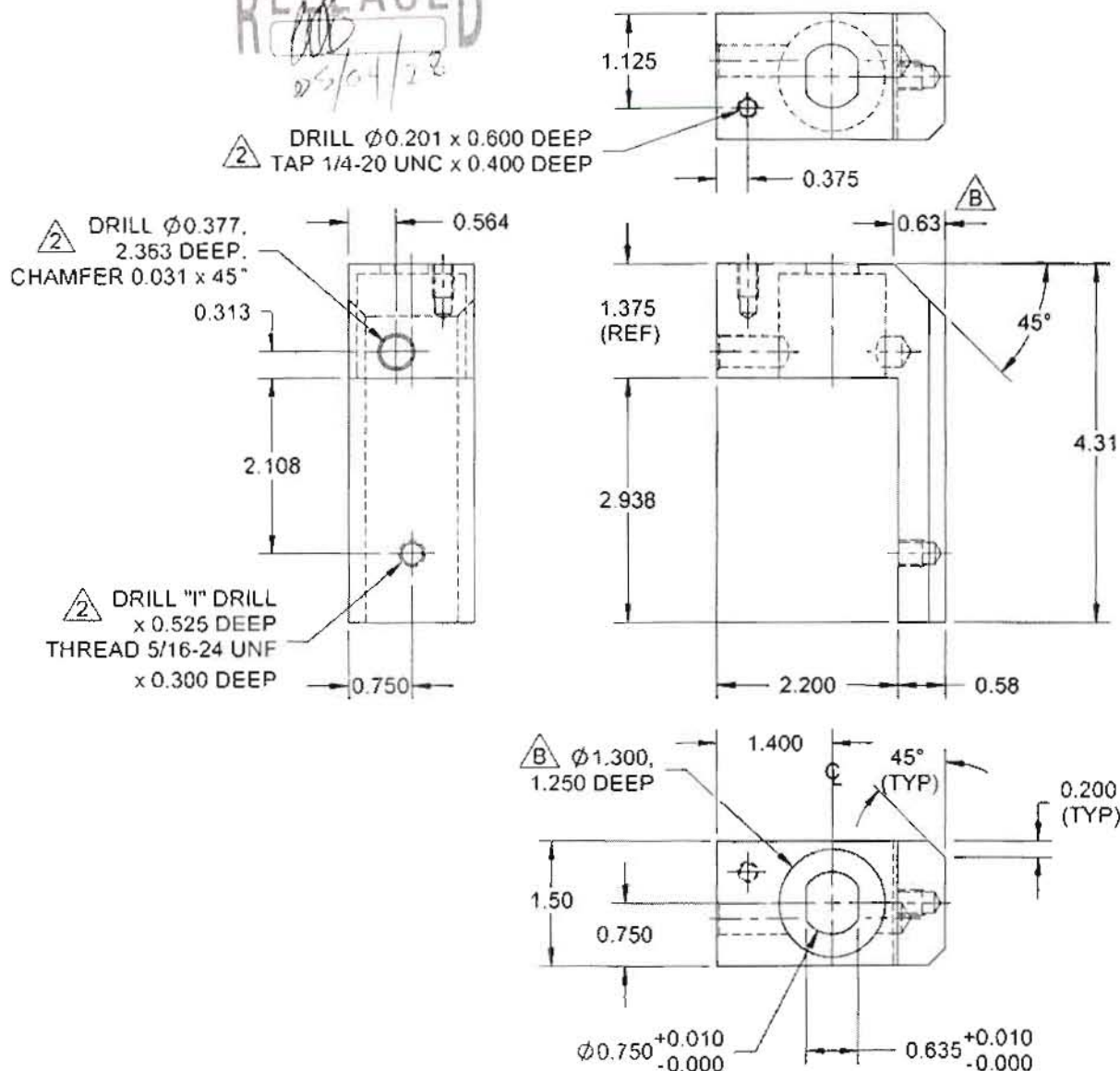
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NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 4 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2

**RELEASED**  
*[Signature]*  
05/04/22**D3372-1 MAIN BODY****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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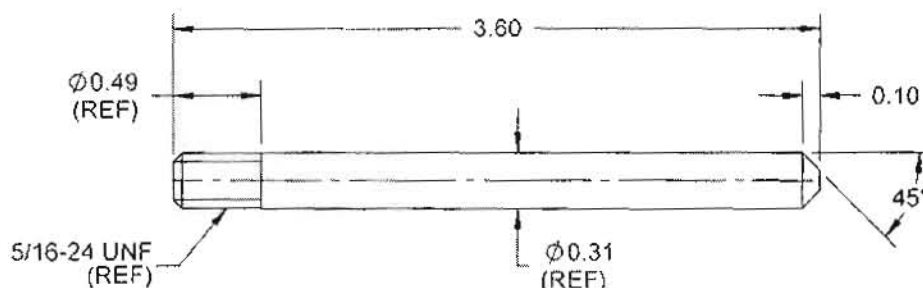
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 5 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

## SPECIFICATION CONTROL DRAWING

RELEASED  
*[Signature]*  
05/04/23



### D3372-3 GUIDE

#### NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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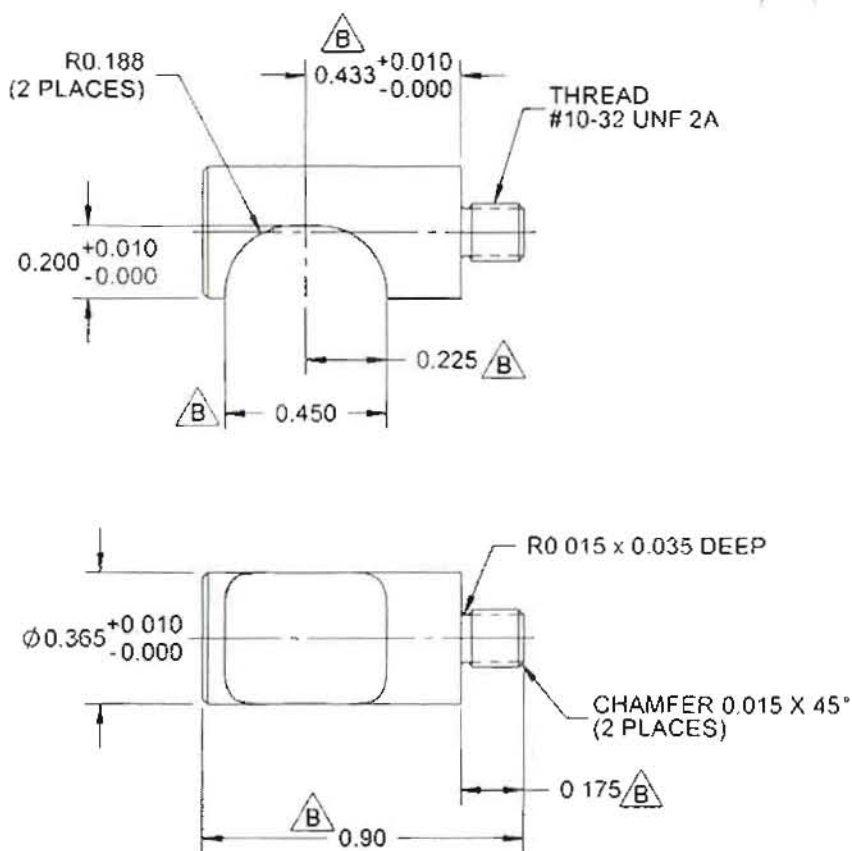
NOTE: Date & initial all entries



**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 6 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

RELEASED  
*[Signature]*  
05/04/28



### D3372-5 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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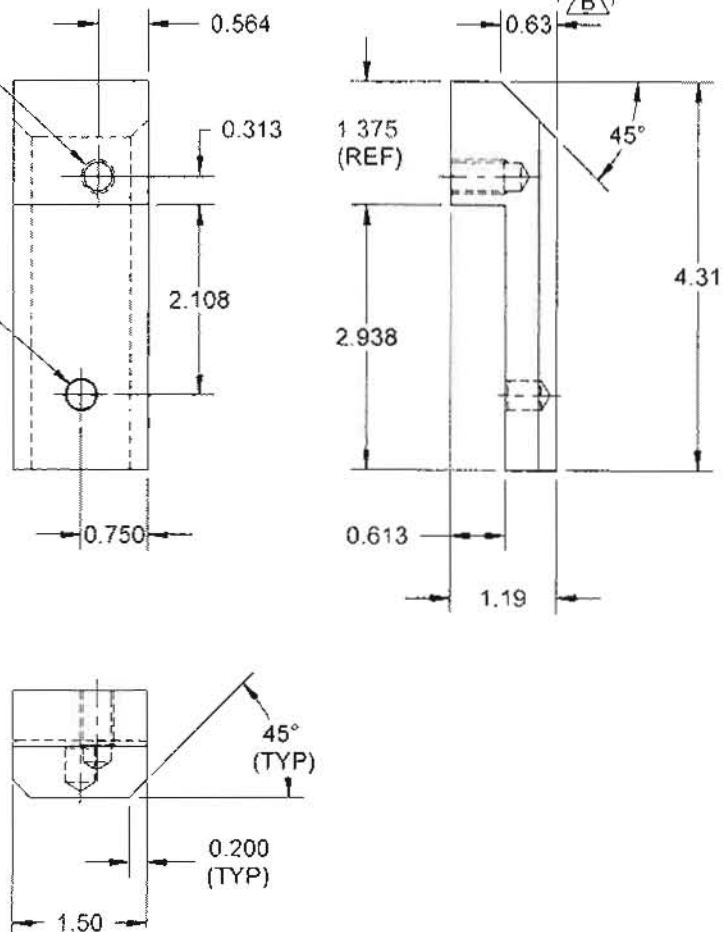
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 7 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2

DRILL  $\varnothing 0.332$   
("Q" DRILL) x 0.881 DEEP,  
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL  $\varnothing 0.323$   
("P" DRILL) x 0.500 DEEP  
CHAMFER 0.030 x 30°



### D3372-7 SLIDER BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

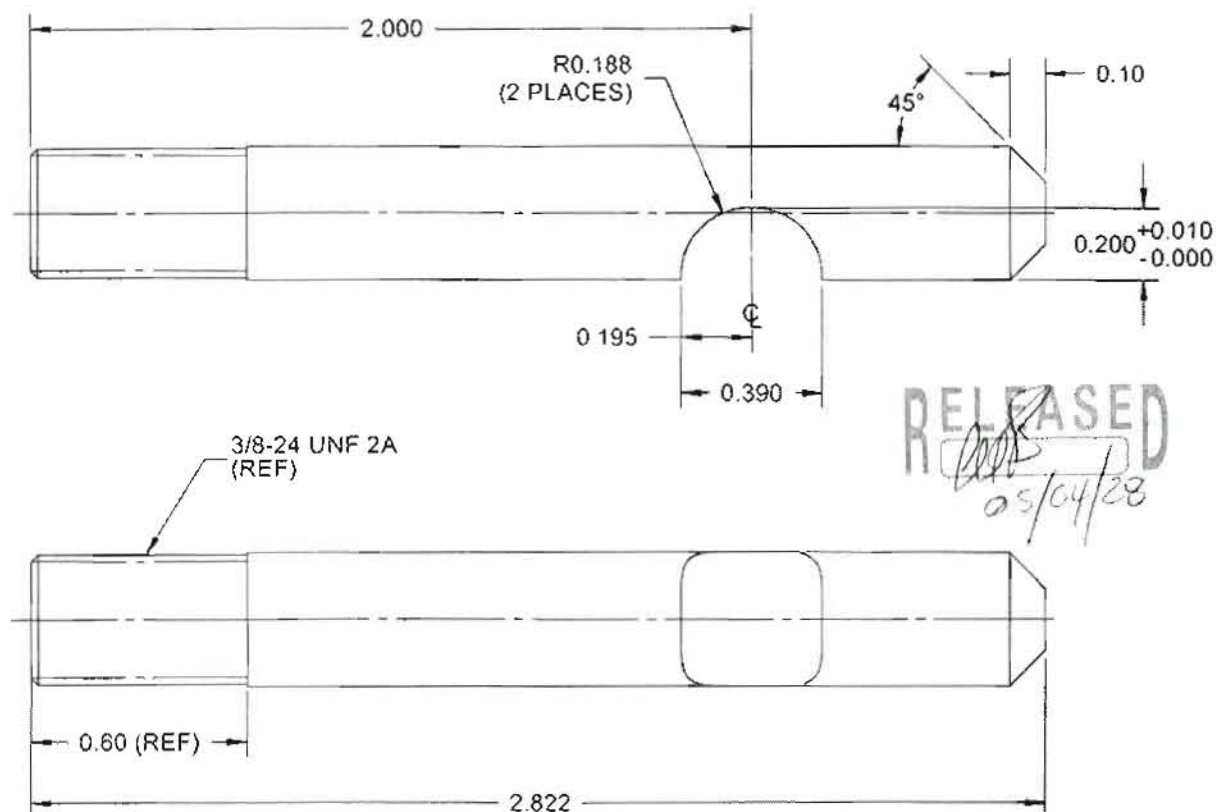
NOTE: Date & initial all entries



**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

## SPECIFICATION CONTROL DRAWING



### D3372-9 LOCK GUIDE

#### NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries